



Date: Wednesday, 3/14/2007 3:30:31 PM
User: Kim Johnston

Process Sheet



Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BELL CRANK
Job Number	: 31220	Part Number	: D2056
Estimate Number	: 11967	Drawing Number	: D2056 REV B2
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 3/14/2007	Drawing Revision	: B2
Prsht Rev.	: NC	Material	: N/A
First Issue	: 3/14/2007	Due Date	: 3/26/2007
Previous Run	: 26524	Qty:	30 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	: Est. E 02.04.04 Added Rev.B2 NG		

Additional Product



Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"
		



Comment: Qty.: 0.2494 f(s)/Unit Total: 7.4813 f(s) *M103220 (83 parts)*
6061-T6 Bar 1.25 x 1.25"
Material: 6061-T6, 1.250" x 1.250" Batch: *M103629, SA 07.03.20 30*

2.0	BAND SAW	BAND SAW
		



11.12 Comment: BAND SAW
Cut blanks 2.80" long *SD 07.03.20 30*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		

Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per folio D2056
Tumble
Deburr any rough edges after tumbling *9m2/SD 07.03.20 30*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		

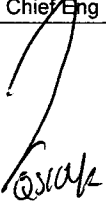
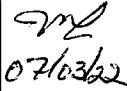
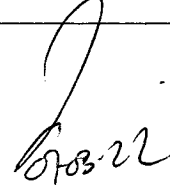


Comment: INSPECT PARTS AS THEY COME OFF MACHINE *9m2/SD 07.03.21 30*

5.0	QC8	SECOND CHECK
		

Comment: SECOND CHECK *J.L 07/03/22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/20	3	1 piece scrap, pop out of the vice.		destroy scrap and replace	 07/03/20			

NOTE: Date & initial all entries

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Drawing Name: BELL CRANK

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-03-26

(30)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

MS

07-03-27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/3/28

(30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/3/28

(30)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

Job Completion



07-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

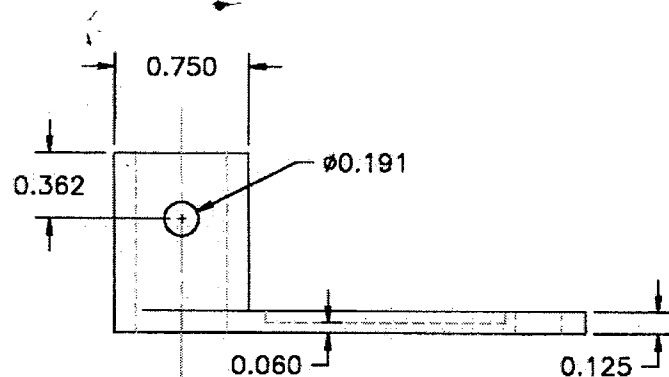
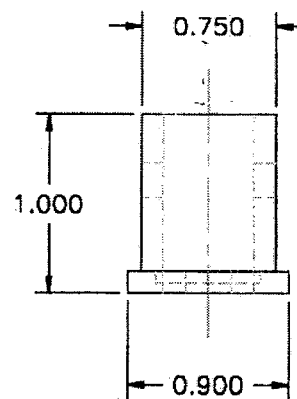
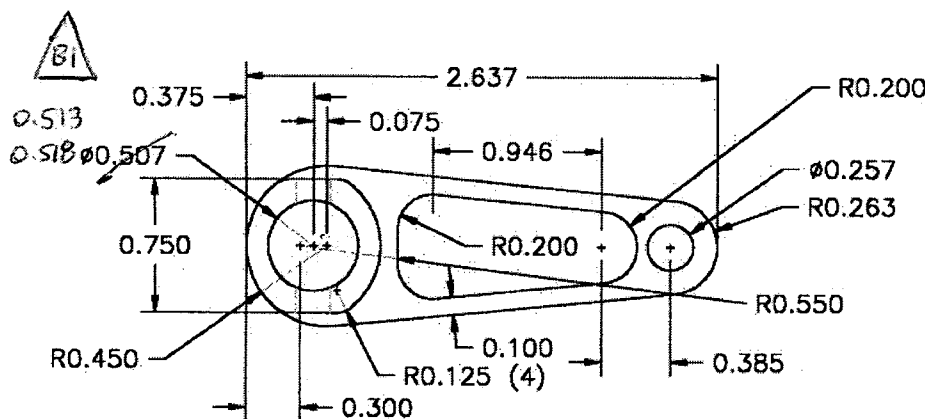
NOTE: Date & initial all entries

DART



RELEASED
19.04.29 AE

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
B WILLIAMS	K HAND	
CHECKED	APPROVED	DRAWING NO.
<i>AE</i>	<i>AE</i>	D2056
DATE		TITLE
92:03:13		BELL CRANK
	95:11:02	RE-DESIGN
B		
B1	<i>AE</i> 01.06.04	MODIFY HOLE SIZE, ADD P/LC OF 7mm
B2	<i>CP</i> 01.12.20	ADD NOTE ON TOLERANCES
		REV. B
		SHEET 1 OF 1
		SCALE
		1:1



B1 ACID ETCH + ANODIZE PER DART BSE COS 4.1
POWDER COAT BLACK FINISH (4.3.5.7) PER DART BSE COS 4.3

B2

MATERIAL: 6061-T6 (QQ-A-225/8)
FINISH: ANODIZE (BLACK) OR
TOLERANCES ARE PER DART BSE 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31220

DART AEROSPACE LTD		Work Order: 31220
Description: D2056		Part Number: D2056
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐

First Article

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Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.637	$\pm .010$	2.634	/			
B .375	$\pm .010$.376	/			
C $\phi .513^{+0.010}_{-0.010}$	N/A	$\phi .515$	/			
D .750	$\pm .010$.749	/			
E .100	$\pm .010$.104	/			
F $\phi .257$	$\pm .006$ $- .001$	$\phi .258$	/			
G						
H .750	$\pm .010$.750	/			
I .362	$\pm .010$.371	/			
J $\phi .191$	$\pm .005$ $- .001$	$\phi .192$	/			
K .060	$\pm .010$.061	/			
L .125	$\pm .010$.127	/			
M						
N .750	$\pm .010$.749	/			
O 1.000	$\pm .010$	1.003	/			
P .900	$\pm .010$.896	/			
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>SN/mf</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07.03.20	Date: 07/03/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	